DESCRIPTION:
SFH-17S is a submerged arc flux cored wire with low alloy steel composition. It is used for build-up and hardsurfacing on mild and low alloy steel components before final overlay, and as a final surface for metal-to-metal wear with moderate impact. Good resistance to compression and cold work deformation with excellent impact resistance and crack susceptibility.

APPLICATIONS:
It is used for work rollers, idlers, carbo steel crane wheels, mine car wheels, and surfaces subjected to the sliding metal to metal wear. Weld deposition could be flame cut or machined.

NOTE ON USAGE:
1. Use DC (+) polarity
2. Application recommendations for high thickness, big angle curvature of workpiece surface to avoid cracks.
   *Preheat and interpass temperatures 200~400°C
   *Control low cooling speed.
3. Recommended flux SF80

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
Weld Metal Analysis:
Carbon (C) 0.09
Manganese (Mn) 2.55
Silicon (Si) 0.57
Chromium (Cr) 2.45
Molybdenum (Mo) 0.56

TYPICAL HARDNESS OF WELD METAL:

<table>
<thead>
<tr>
<th>Layer</th>
<th>1st layer</th>
<th>2nd layer</th>
<th>3rd layer</th>
</tr>
</thead>
<tbody>
<tr>
<td>HRC</td>
<td>29</td>
<td>33</td>
<td>35</td>
</tr>
</tbody>
</table>

SUGGESTED WELDING PARAMETERS (DC <+>)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>3.2mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage (Volt)</td>
<td>28 ~ 32</td>
<td></td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>350 ~ 450</td>
<td></td>
</tr>
<tr>
<td>Stickout (mm)</td>
<td>25 ~ 40</td>
<td></td>
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</tbody>
</table>